

Appl. No. 10/731,452  
Amdt. Dated October 16, 2006  
Reply to Office Action of July 31, 2006

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**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Currently Amended) A five layer shrink film comprising:

a first outer polyethylenic layer;

a second outer polyethylenic layer;

a core polystyrenic layer comprising from 70% to ~~90%~~ 75% by weight ~~styrene~~

homopolymer of styrenes, from 10% to 15% by weight polystyrene toughener, from

10% to 20% by weight adhesive resin, and from 5% to 6% by weight slip additive;

a first polystyrene compatibilizing layer between the core polystyrenic layer and the first

outer polyethylenic layer; and

a second polystyrene compatibilizing layer between the core polystyrenic layer and the

second outer polyethylenic layer;

wherein the polystyrene compatabilizing layers comprise less than 1% by weight

substantially random interpolymer.

2. (Previously Presented) The film of claim 1 wherein the first and second polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.

3. (Previously Presented) The film of claim 2 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1% to 10% by weight 1-octene monomer.

4. (Canceled).

5. (Currently Amended) The film of claim ~~4~~ 1 wherein the polystyrene toughener is selected from the group consisting of styrene-isoprene diblock copolymer, styrene-isoprene

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- triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.
6. (Previously Presented) The film of claim 1 wherein the slip additives in the polystyrenic layer are selected from the group consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
7. (Previously Presented) The film of claim 1 wherein each of the first and second polystyrenic compatibilizing layers comprise from 70% to 90% by weight linear low density polyethylene copolymer and from 5% to 20% by weight of an adhesive resin used as a polystyrene compatibilizing agent.
8. (Previously Presented) The film of claim 7 wherein the adhesive resin is selected from the group consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
9. (Withdrawn) A method of forming a five layer shrink film comprising two outer most polyethylenic layers, an innermost polystyrenic layer and a polystyrene compatibilizing layer situate between each outermost polyethylenic layer and the core polystyrenic layer comprising less than 1% by weight substantially random interpolymers, the method comprising of:  
feeding individual layer compositions into 3 or more separate extruders;  
extruding the compositions simultaneously into a biaxial film orienting means; and

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biaxially orienting the film to a thickness of 40 to 100 gauge;

wherein a separate extruder extrudes a single homogenous composition.

10. (Withdrawn) The method of claim 9 wherein the biaxial film orienting means consists of a double-bubble film orienting process.
11. (Withdrawn) The method of claim 9 wherein the polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.
12. (Withdrawn) The method of claim 11 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1 to 10 weight percent 1-octene monomer.
13. (Withdrawn) The method of claim 9 wherein the polystyrenic layers comprise from 70% to 90% polystyrenic polymer and from 10% to 15% polystyrene toughener by weight of the layer.
14. (Withdrawn) The method of claim 13 wherein the polystyrene toughener is selected from the group of tougheners consisting of styrene-isoprene diblock copolymer, styrene-isoprene triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.
15. (Withdrawn) The method of claim 13 wherein the polystyrenic layer further comprises 5 to 6% slip additives selected from the group of slip additives consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
16. (Withdrawn) The method of claim 9 wherein the polystyrenic compatibilizing layers comprise from 70% to 90% linear low density polyethylene copolymer and from 5% to 20% of an adhesive resin used as a polystyrene compatibilizing agent, by weight of the layer.

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17. (Withdrawn) The method of claim 16 wherein the adhesive resin is selected from the group of adhesive resins consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
18. (Withdrawn) A five layer shrink film comprising:
- a first outer polystyrenic layer;
  - a second outer polystyrenic layer;
  - a core polyethylenic layer;
  - a first polystyrene compatibilizing layer between the core polyethylenic layer and the first outer polystyrenic layer; and
  - a second polystyrene compatibilizing layer between the core polyethylenic layer and the second outer polystyrenic layer;
- wherein the polystyrene compatibilizing layers comprise less than 1% by weight substantially random interpolymer.
19. (Withdrawn) The film of claim 18 wherein the polyethylenic layers comprise at least 80% linear low density polyethylene copolymer.
20. (Withdrawn) The film of claim 19 wherein the linear low density polyethylene copolymer is a copolymer comprising from 1 to 10 weight percent 1-octene monomer.

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21. (Withdrawn) The film of claim 18 wherein the polystyrenic layers comprise from 70% to 90% polystyrenic polymer and from 10% to 15% polystyrene toughener by weight of the layer.
22. (Withdrawn) The film of claim 21 wherein the polystyrene toughener is selected from the group of tougheners consisting of styrene-isoprene diblock copolymer, styrene-isoprene triblock copolymer, and blends of styrene-isoprene diblock copolymer and styrene-isoprene triblock copolymer.
23. (Withdrawn) The film of claim 21 wherein the polystyrenic layer further comprises 5 to 6% slip additives selected from the group of slip additives consisting of primary amides, secondary amides, ethylenebisamides and 13-docosenamide.
24. (Withdrawn) The film of claim 18 wherein the polystyrenic compatibilizing layers comprise from 70% to 90% linear low density polyethylene copolymer and from 5% to 20% of an adhesive resin used as a polystyrene compatibilizing agent, by weight of the layer; and wherein the adhesive resin is selected from the group of adhesive resins consisting of styrene-ethylene butylene-styrene block copolymer, anhydride-modified ethylene vinyl acetate, styrene-butadiene block copolymer, styrene-butadiene rubber, butadiene rubber, styrene-isoprene block copolymer, hydrogenated styrene-isoprene block copolymer, and styrene-butadiene-methyl methacrylate copolymer.
25. (Currently Amended) A five layer shrink film comprising:
  - a first outer polyethylenic layer comprising 15% to 25% by weight of the film;
  - a second outer polyethylenic layer comprising 15% to 25% by weight of the film;
  - a core polystyrenic layer comprising 30% to 50% by weight of the film, the polystyrenic

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- layer comprising from 70% to ~~90%~~ 75% by weight of the layer ~~styrene~~  
homopolymer of styrenes from 10% to 15% by weight of the layer polystyrene  
toughener, from 10% to 20% by weight of the layer adhesive resin, and from 5% to  
6% by weight of the layer slip additive;
- a first polystyrene compatibilizing layer between the core polystyrenic layer and the first  
outer polyethylenic layer comprising 10% to 25% by weight of the film;
- a second polystyrene compatibilizing layer between the core polystyrenic layer and the  
second outer polyethylenic layer comprising 10% to 25% by weight of the film;
- wherein the first and second polystyrene compatabilizing layers comprise less than 1% by  
weight substantially random interpolymer; and
- wherein each of the first and second polystyrene compatabilizing layers comprise 5% to  
20% by weight of the layer anhydride-modified ethylene vinyl acetate.
26. (Currently Amended) A five layer shrink film comprising:
- a first outer polyethylenic layer comprising 15% to 25% by weight of the film;
- a second outer polyethylenic layer comprising 15% to 25% by weight of the film;
- a core polystyrenic layer comprising 30% to 50% by weight of the film;
- a first polystyrene compatibilizing layer between the core polystyrenic layer and the first  
outer polyethylenic layer comprising 10% to 25% by weight of the film;
- a second polystyrene compatibilizing layer between the core polystyrenic layer and the  
second outer polyethylenic layer comprising 10% to 25% by weight of the film;
- wherein the polystyrenic layer comprises ~~70% to 90%~~ 75% by weight of the layer ~~styrene~~  
homopolymer of styrenes; 10% to 15% by weight of the layer polystyrene

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toughener, 10% to 20% by weight of the layer adhesive resin and from 5% to 6% by weight of the layer slip additive;

wherein the first and second polystyrene compatibilizing layers together comprise less than 1% by weight interpolymer; and

wherein the first and second polystyrene compatibilizing layers each comprise 5% to 20% by weight of the layer styrene-ethylene butylene-styrene block copolymer.

27. (Previously Presented) The film of claim 1 wherein the core polystyrenic layer comprises  $\alpha$ -methylstyrene homopolymer.
28. (Previously Presented) The film of claim 1 wherein the core polystyrenic layer comprises styrene.